

Work Order ID 143803

Wednesday, March 23, 2016 8:22:40 AM

143803

Page 1

Item ID: D2747 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Set Screw
 Start Date: 3/28/2016 Start Qty: 200.00 *200* Cust Item ID:
 Required Date: 3/31/2016 Req'd Qty: 200.00 *200* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: MAR 23 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2747	Rev B								
100 *100* Purchasing Purchasing	PURCHASING Memo Issue P/O: <u>31788</u> 3/8"-24 UNF SS Set Screw 7/8" to 1" longPossible Supplie: McMaster CarrP/N:92311A639Material release note required	0.00 0.00				<u>200</u>			MAR 23 2016 DAS 13 9-89
110 *110* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo Ensure material release note is attached	0.00 0.07							<u>200x SP 16-03-28</u>
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				<u>(200)</u>			DAS 38 9-89 MAR 29 2016



DART
AEROSPACE

QA Closed: Date:

7

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I

Work Order ID 143803***143803***

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Wednesday, March 23, 2016 8:22:40 AM

Item ID: D2747 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Set Screw
Start Date: 3/28/2016 Start Qty: 200.00 ***200*** Cust Item ID:
Required Date: 3/31/2016 Req'd Qty: 200.00 ***200*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>5012A</u>	0.00							
130									
Packaging	Memo	0.03					<u>DAS</u>		
Packaging							<u>6</u>		
							<u>9.89</u>		MAR 29 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.33							
Quality Control							<u>MLJ</u>		MAR 30 2016

MLJ **MAR 30 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

Wednesday, March 23, 2016 8:22:43 AM

Page 1

Work Order ID: 143803

143803

Parent Item: D2747

D2747

Parent Item Name: Set Screw

Start Date: 3/28/2016

Required Date: 3/31/2016

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP: B05.08.22ReformatKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

92311A639

Purchased

No

Each

0.0000

200

92311A639

SS SET SCREW

200R 8/16-05-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

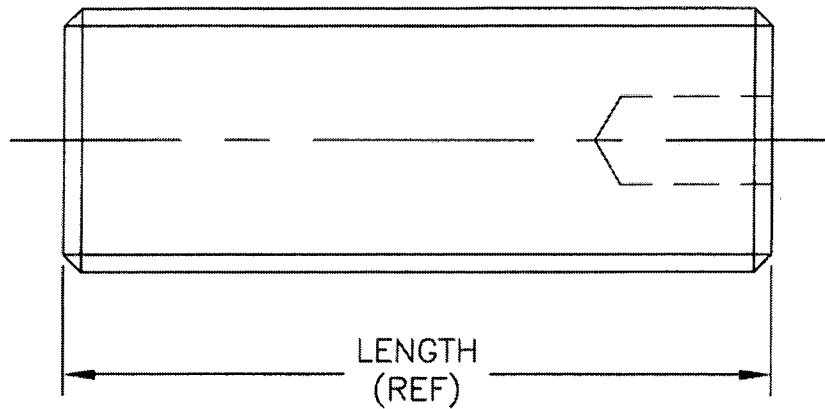
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2747	REV. B SHEET 1 OF 1
DATE 05.03.09		TITLE SET SCREW	SCALE NTS
A	98.08.26	NEW ISSUE	
B	05.03.09	REDRAWN, STAINLESS STEEL ONLY	

RELEASED
05.08.09 *[Signature]*

**D2747 SET SCREW**

- 1) TYPE: HEX SOCKET HEAD SET SCREW
- 2) MATERIAL: STAINLESS STEEL
- 3) THREAD: 3/8"-24 UNF
- 4) LENGTH = 7/8" TO 1"
- 5) FINISH: NONE
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 143803 M05
1603-23

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31788

Purchase Order Date 3/23/2016

PO Print Date 3/23/2016

Page Number 6 of 7

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

Purolator ground ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

17	92311A639	✓	SS SET SCREW	3/28/2016 Yes 3/28/2016	200.00 Each	\$0.66	\$132.38
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AS PER DWG D2747 REV. B
B143803

8016-03-28

Line Total: \$132.38

18	93695K58		WINDOW SEAL	3/28/2016 Yes 3/28/2016	50.00 f	\$0.31	\$15.40
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AS PER DWG D3802 REV. D
B143804

MFG. C OF C REQUIRED

Line Total: \$15.40

19	8672K31		UHMW U-Channel	3/28/2016 Yes 3/28/2016	32.00 f	\$3.26	\$104.32
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AS PER DWG D4287 REV. A
B143802

Line Total: \$104.32

Note:

3/23/2016



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO31788

Order Placed By
Chantal Lavoie

McMaster-Carr Number
8868897-03

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03/23/2016

Line	Product	Ordered	Shipped
1	1145N2 Paint and Drywall Mud Mixing Attachment, 3/8" Shaft Diameter, 24" Shaft Length	1 Each	1
2	2936A16 Coated Carbide 2 in 1 Countersink, Trade Size #4, 82 Degree Angle, TiCN Coating	1 Each	1 ✓
3	26885A46 Cobalt Steel Letter Size Chucking Reamer, Size F, 1-1/2" Flute Length, .2485" Shank Diameter	2 Each	2 ✓
4	11675A41 Under-Mount Drawer Slide, 12" Closed Length	2 Pairs	2 ✓
5	2082A1 Threads Per Inch and Thread Pitch Size Checker	1 Each	1 ✓
6	47865K24 Brass Ball Valve, 3/4" NPT Female Connections	1 Each	1
7	44605K155 Low-Pressure Black Malleable Iron Thread Fitting, 3/4 Pipe Size, Tee	3 Each	3
8	44605K115 Low-Pressure Black Malleable Iron Thread Fitting, 3/4 Pipe Size, 90 Degree Elbow	4 Each	4
9	44615K465 Standard-Wall Black Steel Threaded Pipe Nipple, 3/4 Pipe Size X 4" Length	1 Each	1
10	4457K229 Standard Wall Black Welded Steel Pipe, 3/4 Pipe Size X 16" Length, Threaded Ends	1 Each	1
11	4457K41 Standard Wall Black Welded Steel Pipe, 3/4 Pipe Size X 24" Length, Threaded Ends	1 Each	1
15	44605K344 Low-Pressure Black Malleable Iron Thread Fitting, 3/4 Male X 1/4 Female, Hex Reducing Bushing	3 Each	3
16	91732A734 18-8 Stainless Steel Standard Helical Insert, 1/4"-20 Internal Thread, 0.500" Length, MS122161, Packs of 10	2 Packs	2
17	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10	20 Packs	20
18	93695K58 Oil-Rst Fire-Retardant Blended Buna-N Foam, 50 ft. Adhesive-Back Strip, 1/4" Thickness, 1" WD	1 Each	1
20	63215K52 Stainless Steel Ball Joint Swivel Bearing, PTFE Lined, 1/4" ID, 21/32" OD, 11/32" Ball Thick	10 Each	10

SP/6-03-28

Packing List

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO31788
Order Placed By
Chantal Lavoie

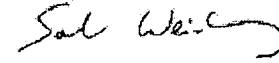
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03/23/2016

McMaster-Carr Number
8868897-03

Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog. Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.



Sarah Weinberg
Compliance Manager

SP16-03-28